

Work Order ID 59912



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June 17, 2010 8:01:12 AM

Item ID: D3407-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Ring

Start Date: 18/06/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 25/06/2010 Req'd Qty: 20.00



Customer:

Reference:

Ind 10.06.18.

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3407

Rev E

100

0.00



FLOW WATER JET

Waterjet

0.00

Memo

1-Cut as per Dwg D3407 ☒ Dwg Rev: E ☐ Prog Rev: E ☐ 2-
Break edges on grinder as per Dwg D3407

Deburr : 5.0/06/30



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

18 10-6-29

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Siobal 30

*count
+22*

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ORC</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

W 10.07.01

Picklist Print

Page 1

June 17, 2010 8:01:12 AM

Work Order ID: 59912

Parent Item: D3407-5

Parent Item Name: Ring



Start Date: 18/06/2010

Required Date: 25/06/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 05-11-22 JLM
IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD
IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174B0.250X4.000		Purchased	No			100	f	0.0000	0.2666	5.612632	5.9		
											18-10-6-29		
17-4 SS Bar .250 X 4.00													

115046

115046

22

FIRST ARTICLE INSPECTION CHECKLIST

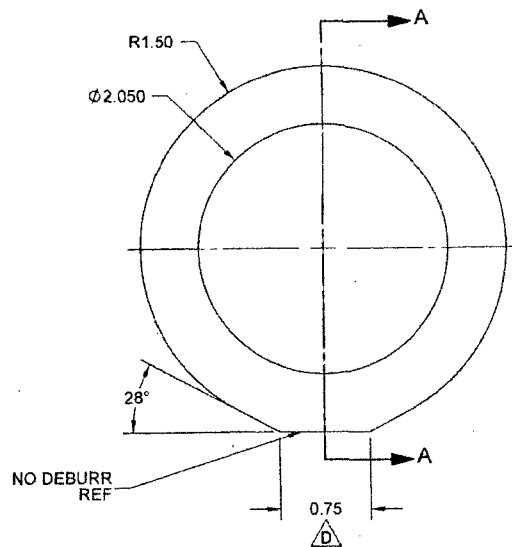
☒ First Article ☐ Prototype

[illegible]

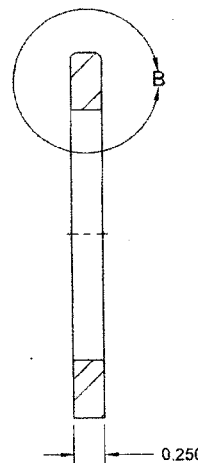
Measured by: B	Audited by: S	Prototype Approval: N/A
Date: 10-6-21	Date: 10/6/30	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.02.02	New Issue	KJ/JLM	
B	07.09.18	Tolerance revised	KJ/EC	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	09.05.04	Dwg Rev updated	KJ/DD	

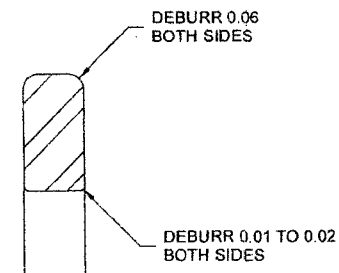
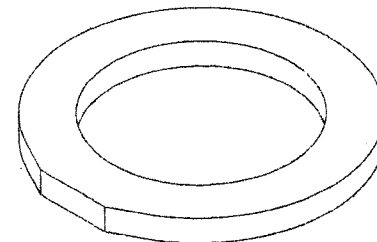
w/o 59912



D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

RELEASED

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

DESIGN	47	DART AEROSPACE USA, INC.	
DRAWN	Per	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	